

5/46

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24712
<b>Description:</b> Bracket Assembly		<b>Part Number:</b>	D3303-043
<b>Dwg:</b> D3303 Rev. A		<b>Qty:</b>	5
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																								
1	DC	Issue Traveler	SP	05.10.26	5																								
2	GA	Assemble as per Dwg D3303 <b>Pick:</b> <table border="0"> <tr> <td><u>Qty</u></td> <td><u>Part Number</u></td> <td><u>Description</u></td> <td><u>Batch</u></td> </tr> <tr> <td>1</td> <td>D3303-1</td> <td>Plate</td> <td>B22107</td> </tr> <tr> <td>1</td> <td>D3303-3</td> <td>Bracket</td> <td></td> </tr> <tr> <td>8</td> <td>MS20426AD3-3</td> <td>Rivet</td> <td></td> </tr> <tr> <td>16</td> <td>MS20470AD4-4</td> <td>Rivet</td> <td>M18729</td> </tr> <tr> <td>4</td> <td>MS21075L3</td> <td>Nut Plate</td> <td></td> </tr> </table> Identify as D3303-043 <i>See W/O B21624B</i>	<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	1	D3303-1	Plate	B22107	1	D3303-3	Bracket		8	MS20426AD3-3	Rivet		16	MS20470AD4-4	Rivet	M18729	4	MS21075L3	Nut Plate		SP	06/03/10	5
<u>Qty</u>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>																										
1	D3303-1	Plate	B22107																										
1	D3303-3	Bracket																											
8	MS20426AD3-3	Rivet																											
16	MS20470AD4-4	Rivet	M18729																										
4	MS21075L3	Nut Plate																											
3	QC5	Inspect work to Step 2	2	06.03.13	5																								
4	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 <b>Mask threads prior to paint</b>	DL	06/03/21	5																								
5	QC3	Inspect Powder Coat	ML	08.03.21	5																								
6	ST	Identify and Stock <i>st 381.</i>	SP	6/3/21	5																								
7	AC	Cost / part: _____	U	06.03.22																									
8	DC	Close W/O Inspect Level 21	SP	06/03/23	5																								

Rev	Date	Change	Revised By	Approved
A	04.09.07	New Issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
*[Signature]* 04.09.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

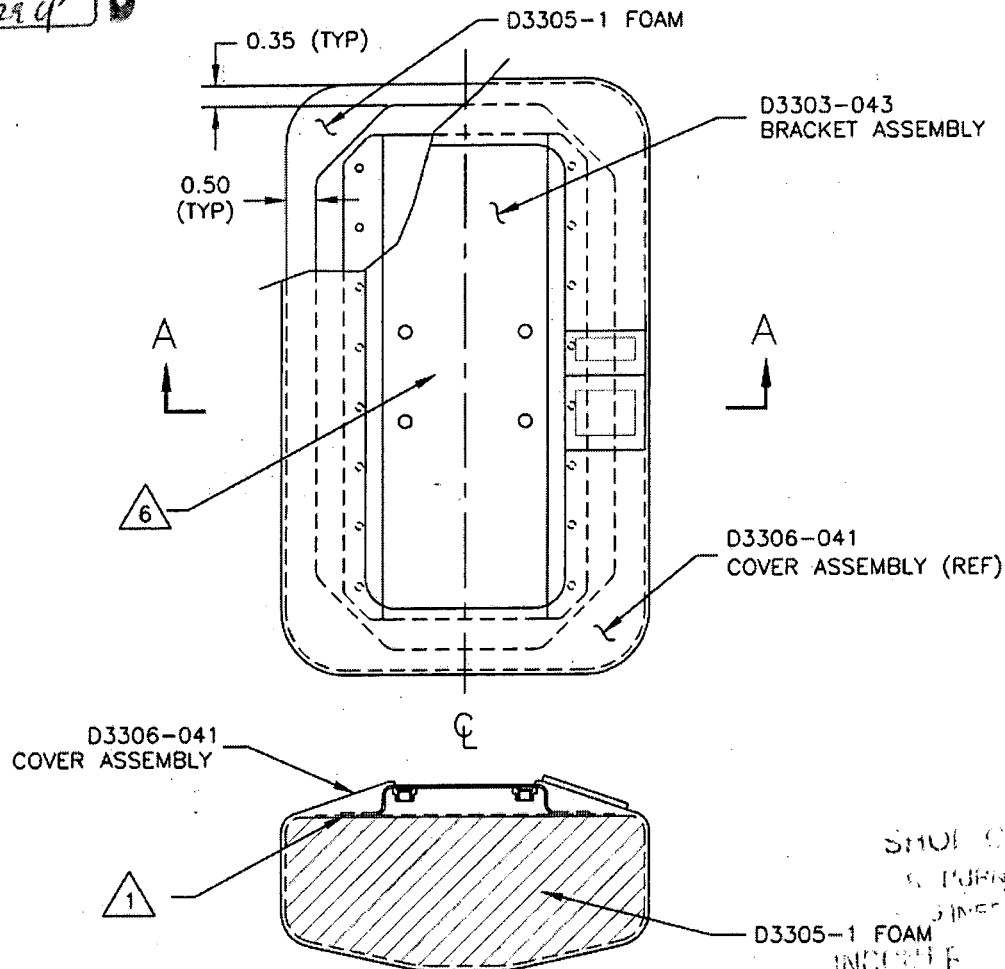
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PP Date: 06/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18	TITLE HEAD REST		SCALE 1:3
A	04.08.18	NEW ISSUE	

**RELEASED**  
04.09.29 U**SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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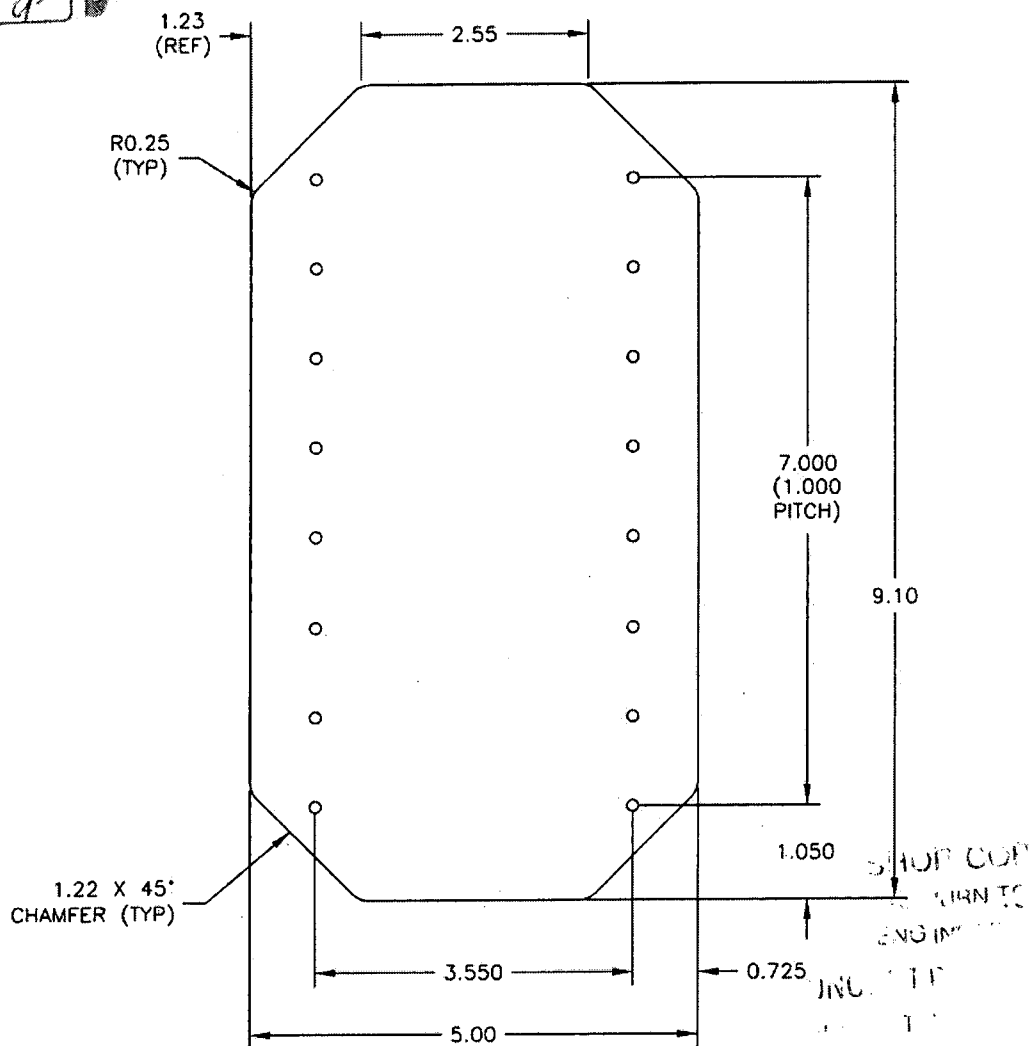
SHOUL  
TURN TO  
DIRECTD3305-1 FOAM  
INCORP  
SUB

WORK

NO 24712

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 3 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**RELEASED**  
04.09.29 *UP***D3303-1 PLATE****D3303-1 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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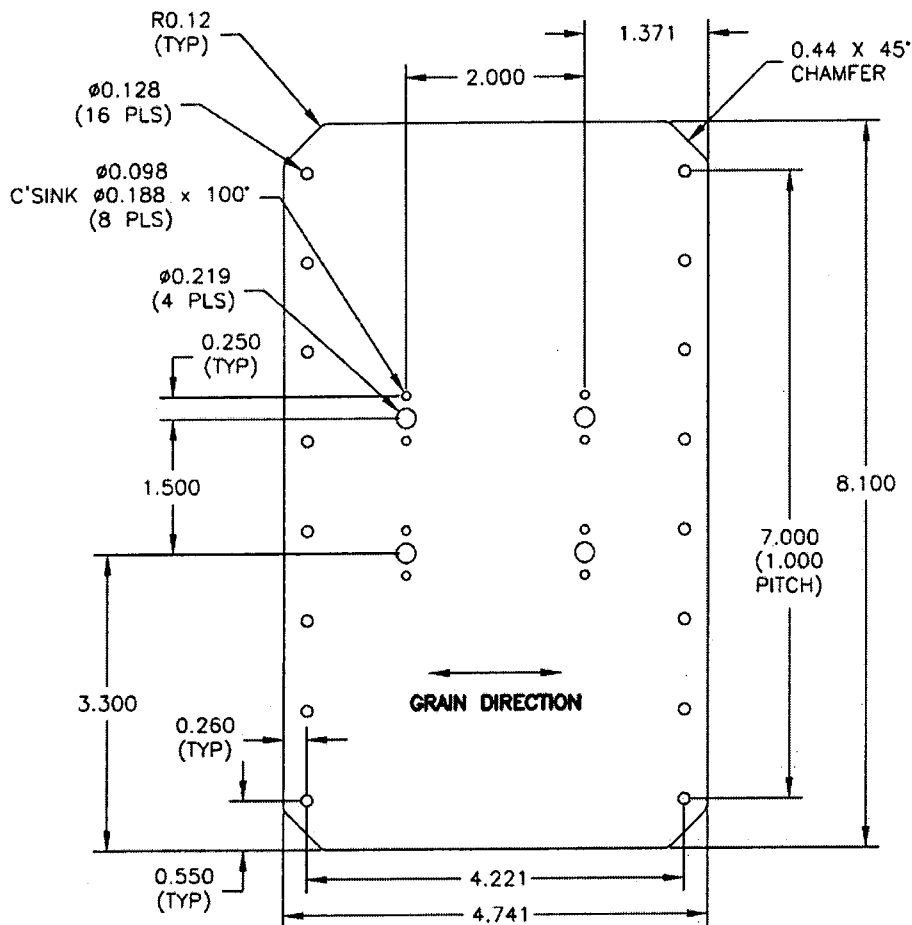
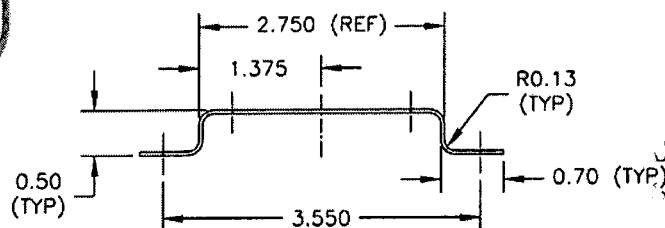
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WORK

NO. 24712

**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 FLAT PATTERN****RELEASED**  
04.09.29 CP**D3303-3 BRACKET  
BEND DETAIL**

SHUT DOWN  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO  
WITH YOU

**WORK C****NO. 24712****D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 26, 2005  
03:12 pm

Work Order No : 0024712  
Project Name : D3303-043  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3303-043  
Description : Bracket Assembly  
Manufactured : Yes  
Amount Req'd : 5  
Amount Done : 0  
Start Date : 10-26-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 08, 2005  
12:45 pm

Work Order No : 0024712  
Project Name : D3303-043  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3303-043  
Description : Bracket Assembly  
Manufactured : Yes  
Amount Req'd : 5  
Amount Done : 0  
Start Date : 10-26-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Mis s/B  
u  
11.15

Date: Monday, 14/11/2005 3:52:17 PM  
 User: Alba Panzuto











## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET ASSEMBLY	
<b>Job Number</b> :	24712			
<b>Estimate Number</b> :	10420			
<b>P.O. Number</b> :		<b>Part Number</b> :	D3303043	
<b>This Issue</b> :	14/11/2005	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3303 REV. A	
<b>First Issue</b> :	/ /	<b>Project Number</b> :		
<b>Previous Run</b> :		<b>Drawing Revision</b> :	A	
	<b>Type</b> :	<b>Material</b> :		
	SMALL /MED FAB	<b>Due Date</b> :	30/11/2005	<b>Qty:</b> 5 <b>Um:</b> Each
<b>Written By</b> :				
<b>Checked &amp; Approved By</b> :				
<b>Comment</b> :	Est: A 04.09.07 New Issue KJ/JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D33031	Plate
2.0	D33033	Bracket
3.0	MS20426AD33	Rivet
4.0	MS20470AD44	Rivet, Universal Head
5.0	MS21075L3	Nutplate
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 		
<b>Comment:</b> SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg D3303 2- Identify as D3303-043		
7.0	QC5	INSPECT WORK TO CURRENT STEP
 		
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		
8.0	POWDER COATING	POWDER COATING
 		
<b>Comment:</b> POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 *****MASK THREADS PRIOR TO PAINT*****		
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
 		
<b>Comment:</b> INSPECT POWDER COAT		
10.0	PACKAGING 1	PACKAGING RESOURCE #1
 		
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: _____		



Date: Monday, 14/11/2005 3:52:17 PM  
User: Alba Panzuto

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24712

Part Number: D3303043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

Job Completion

